

Work Order ID 54805

December 22, 2009 1:25:13 PM

Page 1

Item ID: D3701-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Floor Doubler

Start Date: 1/05/10 Start Qty: 6.00

Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: CY

Date: 09/12/23 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3701

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3701 11 Dwg Rev: A 11 Prog Rev: A 112-

Deburr if necessary

6061 .080

MAT NOT PULLED

RB 10-1-7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB 10-1-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ Siobal 07

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54805

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Page 2

Item ID: D3701-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Doubler

Start Date: 1/05/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

SB 10/03/01

Small Fab

Memo

0.00

6

Small Fab

1- Deburr if necessary 2- form as per dwg D3701

140

0.00



QC5- Inspect part completeness to step on W/O

SL 10/03/01

QC

Memo

0.00

46

Quality Control

150

0.00



Chemical Conversion Coat per QSI005 4.1

BR 10-3-3

HandFinish

Memo

0.00

6

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54805

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Page 3

Item ID: D3701-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Doubler

Start Date: 1/05/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/03/03

(X6) 6

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-3-3 (6x) 5

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/05
ME
10-3-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54805



Parent Item: D3701-1



Parent Item Name: Floor Doubler

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

sf

370.3809

6.6600



6061-T6 .080 Sheet

18 10-1-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

370.38087

110630

33.5136

112141

0.86727

113438

336

112763

112763

6

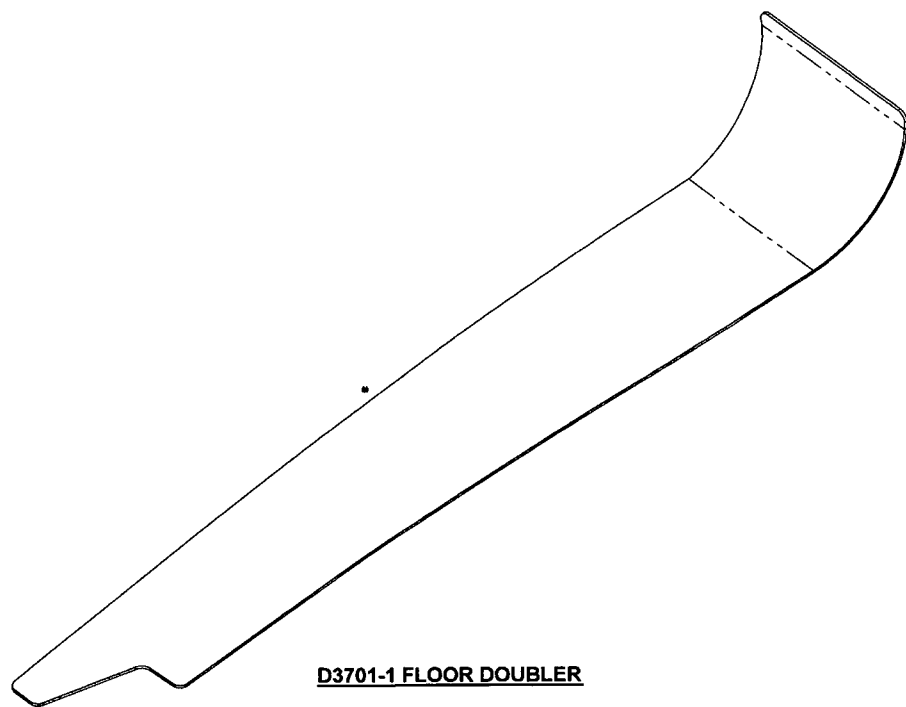
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3701-1 FLOOR DOUBLER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54805

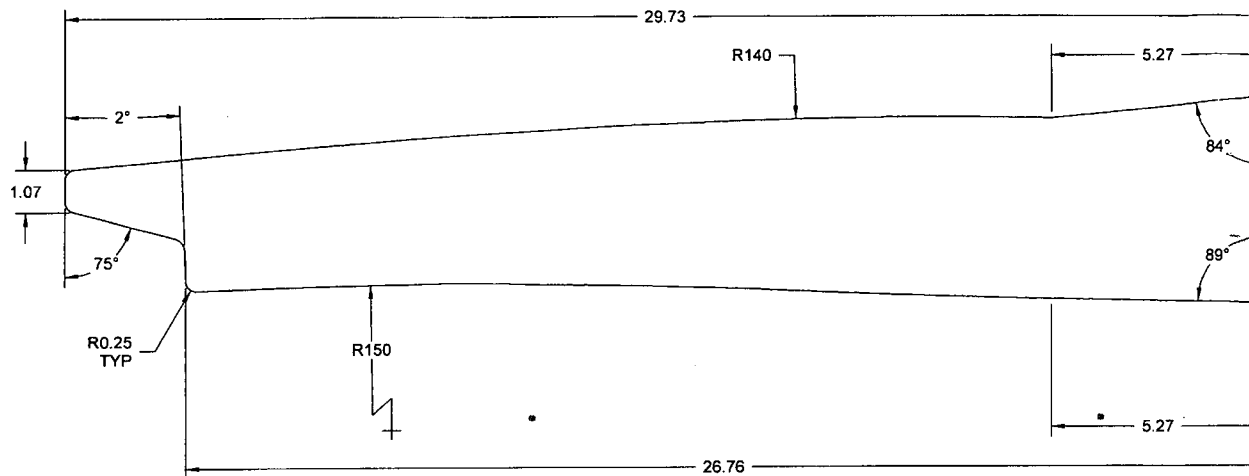
C209112123

RELEASED
09/04/09

NOTES:

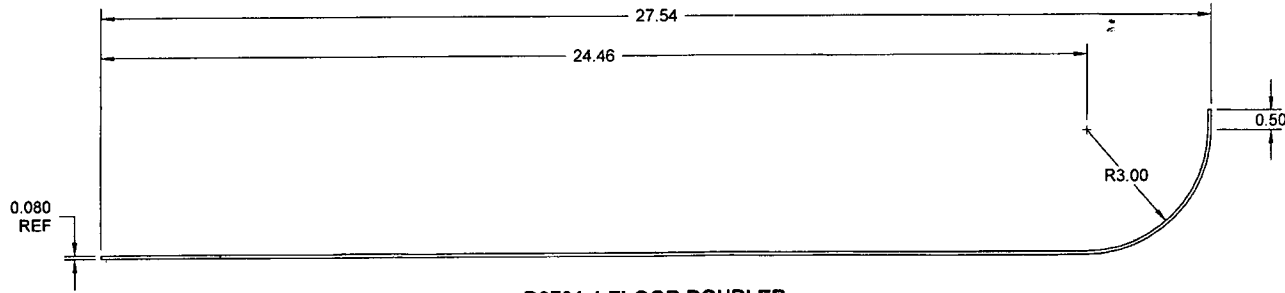
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3701-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs
- 8) MANUFACTURE PART FROM "D3701-1F.DXF" FILE

A		NEW ISSUE		MB		08.04.30	
REV.		DESCRIPTION		BY		DATE	
DESIGN				DART AEROSPACE LTD			
DRAWN				HAWKESBURY, ONTARIO, CANADA			
CHECKED				REV. 			
MFG. APPR.				D3701 SHEET 1 OF 1			
APPROVED				TITLE SCALING			
DE APPR.				FLOOR DOUBLER NT			
DATE				08.04.30		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3701-1F FLAT PATTERN

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WORK ORDER
NO. 54905



D3701-1 FLOOR DOUBLER
(MAKE FROM D3701-1F)

RELEASED
07/04/08

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3701	REV. A
MFG. APPR.		TITLE FLOOR DOUBLER	SHEET 2 OF 2
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